### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-011681 Address: 333 Burma Road **Date Inspected:** 26-Jan-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes NA No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component:** OBG.

## **Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard – 7DW. Notification No: 005086.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

PP57-DP279-001 – 037 to 040, 042 to 045, 047, 048, 050 to 053, 055, 056, 058 to 061.

PP57-DP117-002 – 048 to 051, 053 to 056, 059, 061 to 064, 066, 067, 069 to 072, 077 to 080.

PP57-DP252-001 - 060, 062, 065, 067, 070, 073, 075, 078, 081, 083, 086, 089, 091, 094, 097 & 099.

PP57-DP225-001 - 060, 062, 065, 067, 070, 073, 075, 078, 081, 083, 086, 089, 091, 094, 097 & 099.

PP57-DP198-001 – 059 to 062, 064 to 067, 069, 070, 072 to 075, 077, 078, 080 to 083, 085, 086, 088 to 091, 093,

094 & 096 to 099.

The following weld did not appear to comply with the applicable contract documents:

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#### PP57-DP117-002 - 058.

One (1) transverse linear indication was discovered measuring approximately 6mm in length. The member is identified as the deck panel diaphragm, fillet weld connection to U-ribs. This indication is located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA informed ZPMC Quality Control (QC) identified as Mr. Wang Wei Ming and American Bridge Fluor (ABF) QA identified as Mr. Peter Shaw of this issue and that an incident report would be generated.

For further information, please see the attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.







#### **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

# **WELDING INSPECTION REPORT** ( Continued Page 3 of 3 )

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	OA Reviewer